

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027025**Date Inspected:** 12-Jan-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA**CWI Name:** Chris Concha**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

Repair of Dented Truss Members on the E2/E3-WB Traveler (North end)

QA Inspector randomly observed WMI personnel Mr. Jose Delgadillo WID#3193 performing fit-up and tack welding on E2/E3-WB-439-SK (TSS 76 x76 x 76) "Band-Aid repair", WJ# AR2, using approved FCAW process. Later in the day QA Inspector randomly observed WMI production welder Mr. Daniel Grayum (WID # 3049) performing Flux Core Arc Welding (FCAW) activities on the E2/E3-WB-439-SK (TSS 76 x76 x 76) "Band-Aid repair", WJ# AR2. Welding completed on this date. For additional information on the above repair review contract document ABF-RFI-002647R00 dated November 18, 2011 and sketch – SK-2647R0 dated November 28, 2011. Repair appears to comply with contract documents.

SAS-EB Traveler

This QA Inspector randomly observed WMI production welder Mr. Daniel Grayum (WID # 3049) grinding to remove paint and performing Flux Core Arc Welding (FCAW) activities on the SAS-EB Traveler sump pump brackets and console brackets. This QA Inspector observed Mr. Grayum tack welding and welding in all positions on angle brackets to tube steel material, randomly throughout the shift.

SAS Travelers Supplementary Platforms

This QA Inspector randomly observed Westmont Industries (WMI) production fitter, Mr. Larry Swanson (WID

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#3058), and observed fitting and welding activities on material, for the SAS Travelers Supplementary Platforms. Mr. Swanson was observed tack welding using approved Flux Cored Arc Welding (FCAW) process, welding in 2F position.

This QA Inspector randomly observed Westmont Industries (WMI) production welder, Mr. Juan Jimenez (WID # 3059), performing welding activities on material, for the SAS Travelers Supplementary Platforms. Mr. Jimenez was observed welding using approved Flux Cored Arc Welding (FCAW) process, welding in 2F position.

Elevating Platforms

This QA Inspector randomly observed WMI shop personnel Mr. Richard Fuentes WID #3201 and helper Mr. Jesus Rayas WID#3197, attaching grading to the steps on the SAS-EB/WB, E2/E3-EB/WB Maintenance Travelers elevating platforms.

E2/E3-WB Traveler

This QA Inspector randomly observed Westmont Industries (WMI) production welder, Mr. Jose Delgadillo (WID # 3193), and observed fitting and tack welding activities on material, for the sump pump assemblies. Mr. Delgadillo was observed tack welding using approved Flux Cored Arc Welding (FCAW) process, welding in 2F position. Reference document ABF-RFI-002498R0.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Chris Concha was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Concha verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

E2/E3-EB Traveler

This QA Inspector performed random shop observations and observed that Zemarc Corporation is on site at WMI today. Mr. Aquirre with Zemarc informed this QA Inspector that Zemarc will be here at WMI installing 2" compressed air line on the E2/E3-EB Traveler today.

RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI is on site at WMI today. QA Inspector was informed by RPI Coating Mr. Preston Keen that RPI will be removing spent abrasive blast material from Bay 6 today.

This QA noted above items observed appear to comply with contract documents.

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Summary of Conversations:

WMI Mr. George Grayum informed QA Inspector that Zemarc Corporation mis-drilled 4 bolt hole for the 2" piping supports brackets at the south end of the E2/E3-EB Traveler in the mid rail tube Assembly 6 (TSS 2 x 2 x 1/8") MK #ec, WMI drawings WMI-E2/E3-325 Revision A. Mr. Grayum stated the WMI will submit Request for Information (RFI) to repair the mis-drilled holes. QA Inspector informed SMR Mr. Nicolai Hvass of the above information.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Brannon, Sherri	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
